

Work Order ID 72570

Friday, July 29, 2011 1:35:05 PM

Page 1

Item ID: D4334-043

Accept

Revision ID:

Item Name: Tail Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00

Required Date: 8/2/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date: 11-07-29 Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4334	A
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100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-Deburr if necessary

2074. 063

B 11-8-2

①

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B 11-8-2

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Subtotal

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72570

Friday, July 29, 2011 1:35:05 PM



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Item ID: D4334-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

132

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: H P M-14/08/03

135

Memo

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4334

*Handwritten: S u los by**Handwritten: 10*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Handwritten: S u los by**Handwritten: 40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 72570

Friday, July 29, 2011 1:35:05 PM



Page 4

Item ID: D4334-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Plate Assembly

Start Date: 7/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/04/11

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/08/11

11-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 29, 2011 1:35:11 PM

Page 1

Work Order ID: 72570

Parent Item: D4334-043

Parent Item Name: Tail Plate Assembly

Start Date: 7/29/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.28 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21069L3		Purchased	No				Each	93.0000		4			
													
ANCHOR NUT													

Location	Loc Qty	Loc Code
ST302	93	
103447	1	
115708	4	
118003	88	

MS20426AD3-4		Purchased	No				Each	5,068.000		8			
													
RIVET													

Location	Loc Qty	Loc Code
ST316	5068	
104374	1142	
110398	3926	

M2024T350.063"

0.155 sglt

batch: 117392

B11-8-2

.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

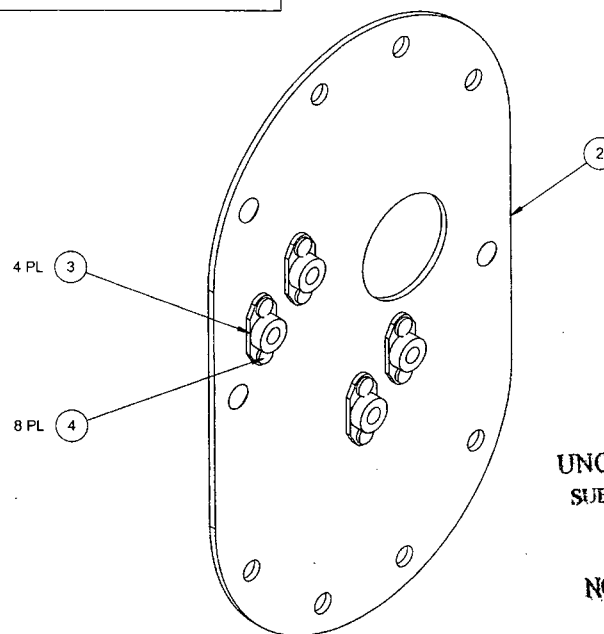
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4334-043	TAIL PLATE ASSEMBLY
2	1	D4334-9	TAIL PLATE
3	4	MS21069-3	NUTPLATE
4	8	MS20426AD3	RIVET
5	8	MS20426AD3-A/R	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72570

11-0729

RELEASED
2011-05-27
MP

D4334-043 TAIL PLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DC</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D4334	SHEET 2 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

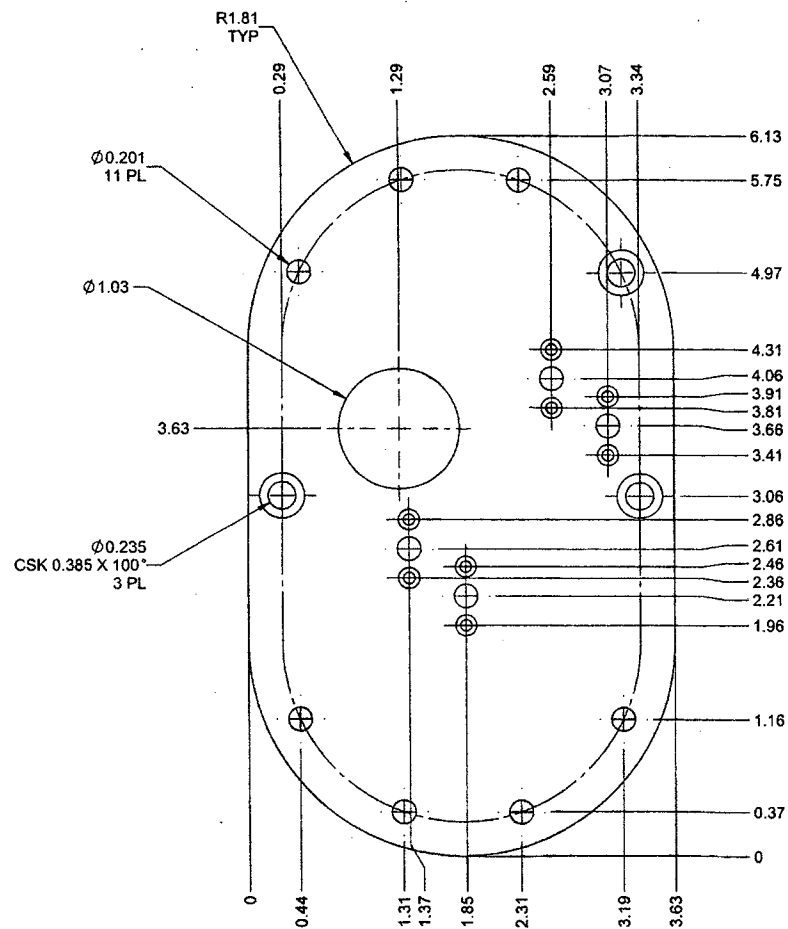
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.063
REF

RELEASED
2011-05-23
JW

D4334-9 TAIL PLATE

NOTES:

- 1) MATERIAL: 2024-T3 OR 6061-T6 ALUMINUM SHEET, 0.063 THK
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	D4334	SHEET 8 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
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DART AEROSPACE LTD		Work Order: 72570
Description: TAIL PLATE ASSEMBLY		Part Number: D4334-043
Inspection Dwg: D4334-9 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 201	+ .005 - .001	201	✓		V HB02	
Ø 235	+ .005 - .001	235	✓		V	
Ø 1.03	+ .02 - .001	1.029	✓		V	
.44	± .03	1442	✓		V	
1.31	± .03	1.313	✓		V	
1.37	± .03	1.374	✓		V	
1.85	± .03	1.850	✓		V	
2.31	± .03	2.310	✓		V	
3.19	± .03	3.193	✓		V	
3.63	± .03	3.634	✓		V	
.29	± .03	.291	✓		V	
1.29	± .03	1.297	✓		V	
2.59	± .03	2.593	✓		V	
3.07	± .03	3.071	✓		V	
3.34	± .03	3.343	✓		V	
.37	± .03	.375	✓		V	
1.16	± .03	1.162	✓		V	
1.96	± .03	1.960	✓		V	
2.21	± .03	2.207	✓		V	
2.36	± .03	2.358	✓		V	
2.46	± .03	2.460	✓		V	
2.61	± .03	2.607	✓		V	
2.86	± .03	2.853	✓		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-8-7	Date: 11/02/03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 72570
Description: TAIL PLATE ASSEMBLY	Part Number: D4334-043
Inspection Dwg: D4334-9, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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[illegible]

Measured by:	RB
Date:	11-8-7

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	